

Date: Tuesday, 09/10/2007 2:55:16 PM  
 User: Linda Lacelle

## Process Sheet

Split 2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35031 -2	Part Number	: D3560043
Estimate Number	: 12883	Drawing Number	: D3560 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 09/10/2007 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 19/10/2007
Previous Run	: 35031	Qty:	5
Written By	:	Um:	10 Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC		
	: Est Rev B ECN 987 07.10.09 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 310-1508

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 15.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: 1/1/04 &amp; Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35031

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
PLATE **3 34478**

*07-11-08*

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- 6- weld across bottom and top ends *th*
- 7- reheat with torch ( — ) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

**770**

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07-11-08* **5**

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07-11-08*

**5X**

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*07/11/14*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/11/14* **5**

01-11-08	7.0	split w/o from 10 on w/o #1 to 5 on w/o #2	pk	01-11-08



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35031

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

batch: B35330

MF 02-11-15

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

MF 07-11-15

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MF 07-11-15 (S)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST152

(x5) L

AS 07/11/15

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/15 (S)

Job Completion



L 07-11-15





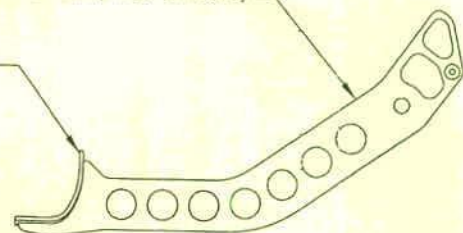






D3560-1 ARM (-041, SHOWN)  
OR D3560-2 ARM (-042, OPPOSITE)

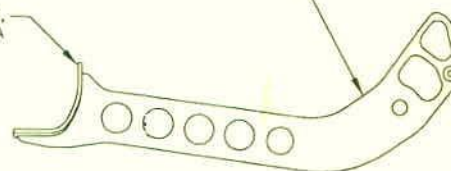
D3592-1 PLATE,  
SEE DETAIL A



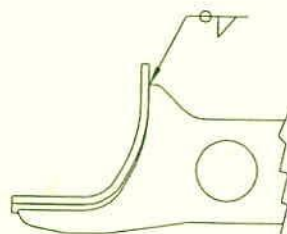
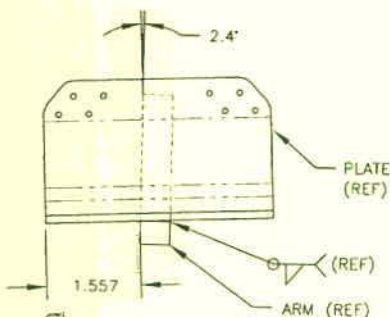
D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)  
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,  
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
07.06.19

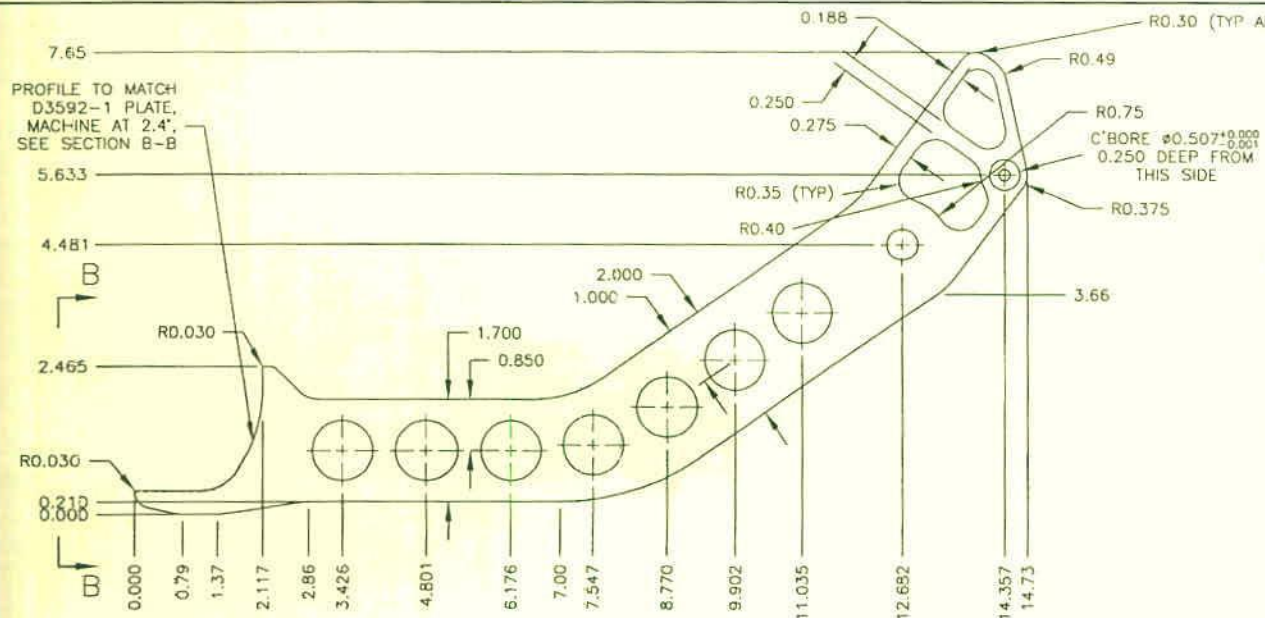
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DESIGN	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DRAWN BY	GP	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	GP	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
APPROVED	GP	REV. C SHEET 1 OF 3 SCALE 1:4

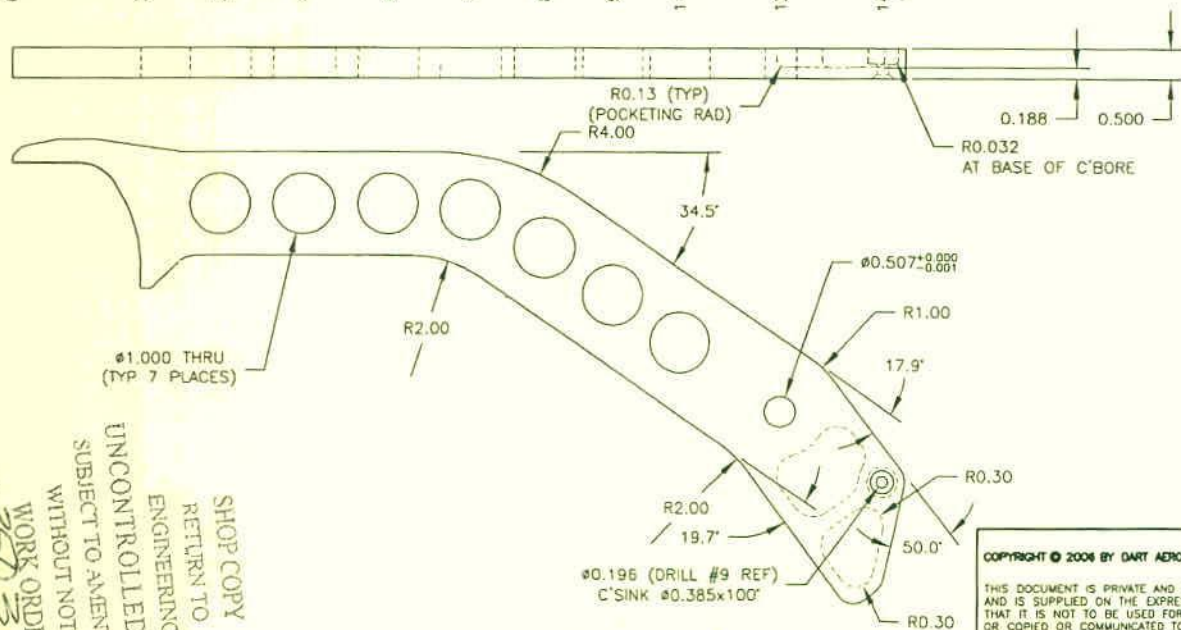
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SHOP COPY



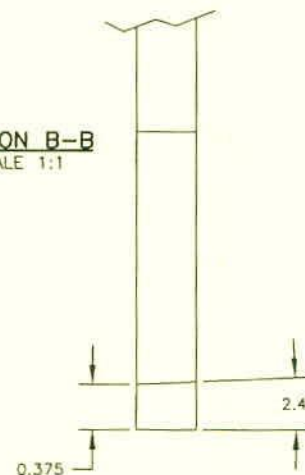


# D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



## SECTION B-B SCALE 1:1



RELEASED  
07.06.19

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WORK ORDER  
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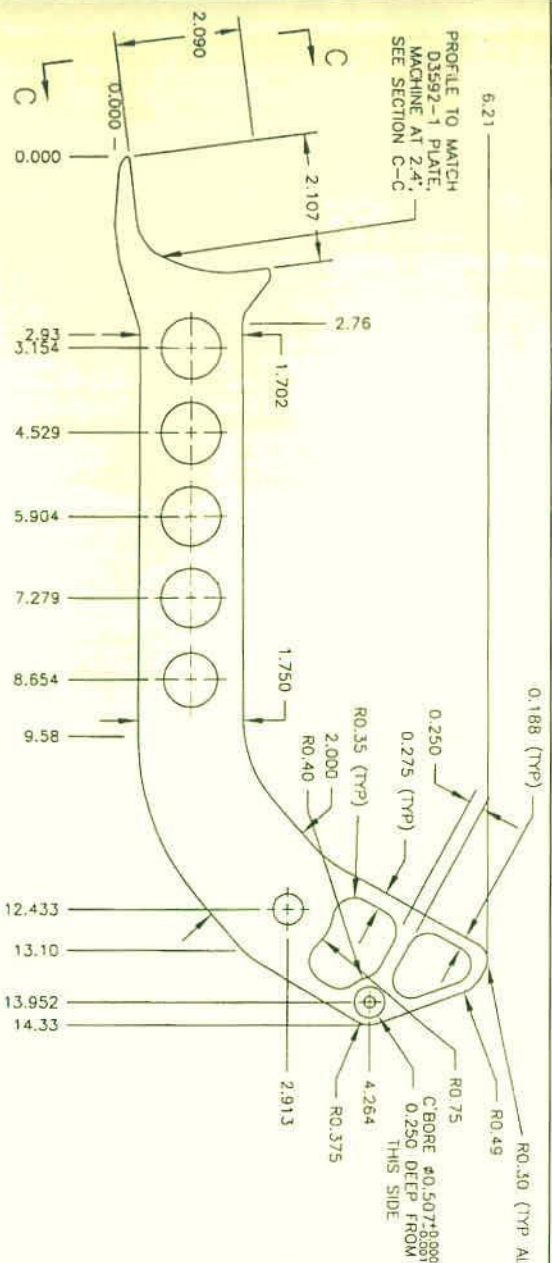
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CHECKED	h	APPROVED	h	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2





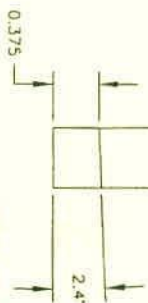


- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

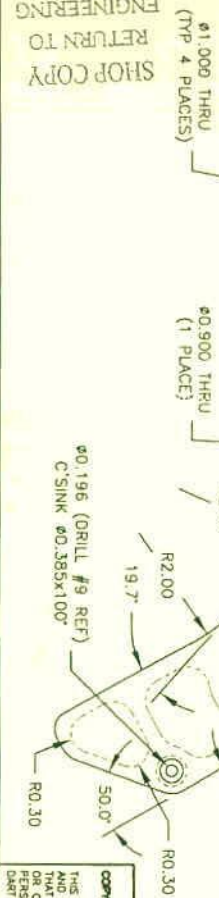
R0.13 (TYP)  
(POCKETING RAD)

R0.032  
AT BASE OF C'BORE

**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



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DESIGN	DATE	DESIGN BY	DATE	APPROVED	TITLE	SCALE
47	07.06.19	47			D3560	1:2
					ARM WELDMENT	

DART AEROSPACE LTD.

RELEASED  
07.06.24

